

**ABSTRACT**

Rolls having a polyurethane elastomer formed from a polyurethane mixture, wherein the polyurethane mixture comprises polydiene, tri-functional polyol curative, an additional graft polymer curative having a molecular weight of at least about 800 and comprising diol, polyol, diamine, polyamine or a combination thereof, conductive modifier, antioxidant, and hydrolytic stabilizer. Methods of forming such rolls include casting the polyurethane mixture, followed by curing, then demolding, grinding to desired dimensions and baking such that the outer layer of the cured roll is oxidized.

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